

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023506**Date Inspected:** 08-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Bay 19 / OBG Bike Path

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG lift 13 East welds as per ZPMC notification # 09071.

The weld designations reviewed are as follows:

BK24A8-001-059~062, 065, 067, 068, 087~092, 094, 095, 098~105, 112

BK24A8-001-040~043, 048, 049, 002, 003, 120, 121

BK24A8-001-071~074

BK24A5-001-039, 040, 045~048, 061~064, 073~076, 085~088, 053, 054

Trial Assembly / OBG segment 13AW-13BW

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of Deck Panel weld # OBW13-001. The welder is identified as 045270. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to

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## WELDING INSPECTION REPORT

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comply with WPS-B-T-2221-B-U2-S-4. See attached photograph Pic\_001.

Trial Assembly / OBG segment 13AE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of CB side SP to BP holdback weld # SEG3007AC-004. The welder is identified as 200113. Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-2214-TC-U4b-FCM-1.

Trial Assembly / OBG segment 13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of BK side SP to BP holdback weld # SEG3009A-001. The welder is identified as 44772. Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-2214-TC-U4b-FCM-1.

Trial Assembly / OBG segment 13BE

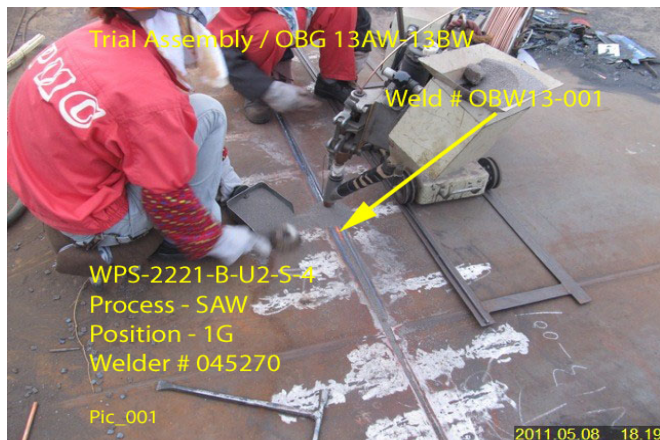
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld # SEG3009S-075. The welder is identified as 051359. Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-2213-TC-U4b-FCM-1.

Trial Assembly / OBG segment 13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld # SEG3009S-051. The welder is identified as 068924. Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS-2211-TC-U4b-FCM-1.



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### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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